

Date: Thursday, 11/15/2007 1:20:20 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	GAS SPRING		
Job Number	35751			Part Number	D2807-041		
Estimate Number	10336			Drawing Number	D2807 UNDER REVIEW		
P.O. Number				Project Number	N/A		
This Issue	11/15/2007	S.O. No.		Drawing Revision	<i>Rev E</i>		
Prsht Rev.	NC			Material	<i>D2807-041</i>		
First Issue	/ /	Type	PURCHASED PARTS	Due Date	12/10/2007	Qty:	100
Previous Run	33941			Um:	Each		
Written By							
Checked & Approved By							
Comment	Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <i>5053</i> <i>100</i> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems or LS Technologies Material release note is required	
2.0	SXF6S6050080S6L115N	GAS SPRING	<i>(PR)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) SUPPORT PROP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	<i>1</i>
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	<i>11/14/09 (20) 11/12/13 100%</i>
4.0	QC6	DIMENSIONAL CHECK	<i>2SP 019</i> <i>count 4100</i>
		Comment: DIMENSIONAL CHECK	
5.0	D28073	Lug	<i>(X) already on g23 strut</i>
		Comment: Qty: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) Pick: 2 D2807-3 Lug Batch:	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2807 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 35751		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/01/01 60		one part was taken for eng. testing incorrect part. *	/	SCRAP - QTY X1 No response used for eng.	N/A	C	/	02/01/01 02/01/01

NOTE: Date & initial all entries

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Drawing Name: GAS SPRING

Job Number: 35751

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Install lugs and crimp using B18791 crimp jig.
- 2-Remove lettering and logo with wash and wipe.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/01 X99

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8748

08/04/01 99

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/01 02

Job Completion



6.0

→ Pick A3671-1 Placard.

08/04/01 00

* And install

Batch: B35964 98

B38205 ②

MF 08-04-02

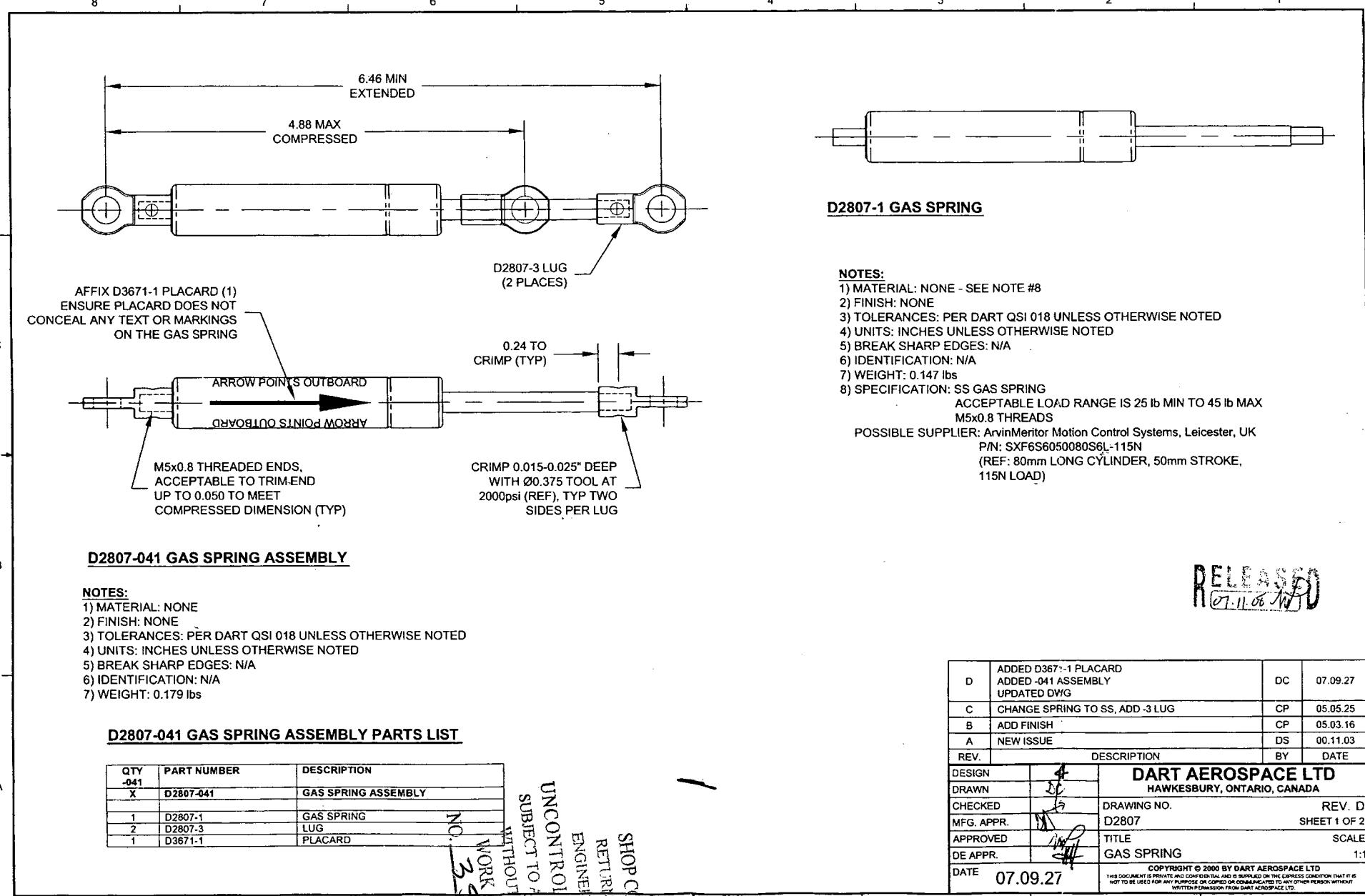
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

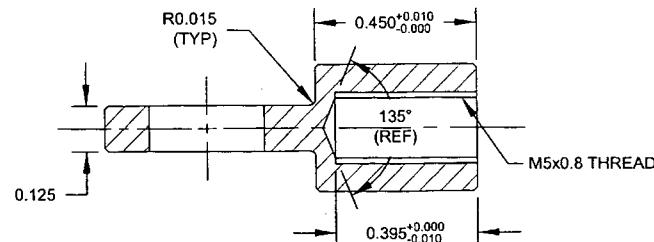
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

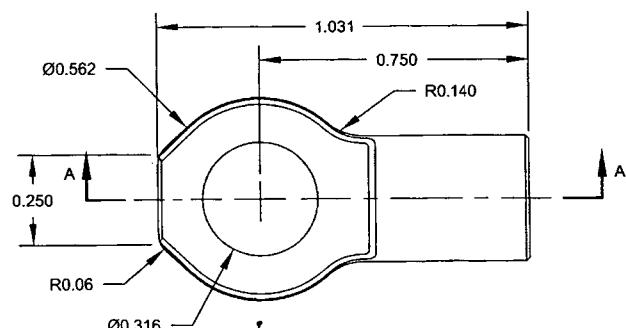
NOTE: Date & initial all entries



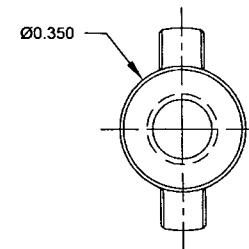
8 7 6 5 4 3 2 1



SECTION A-A



D2807-3 LUG



RELEASED
07-11-08 JH

NOTES:

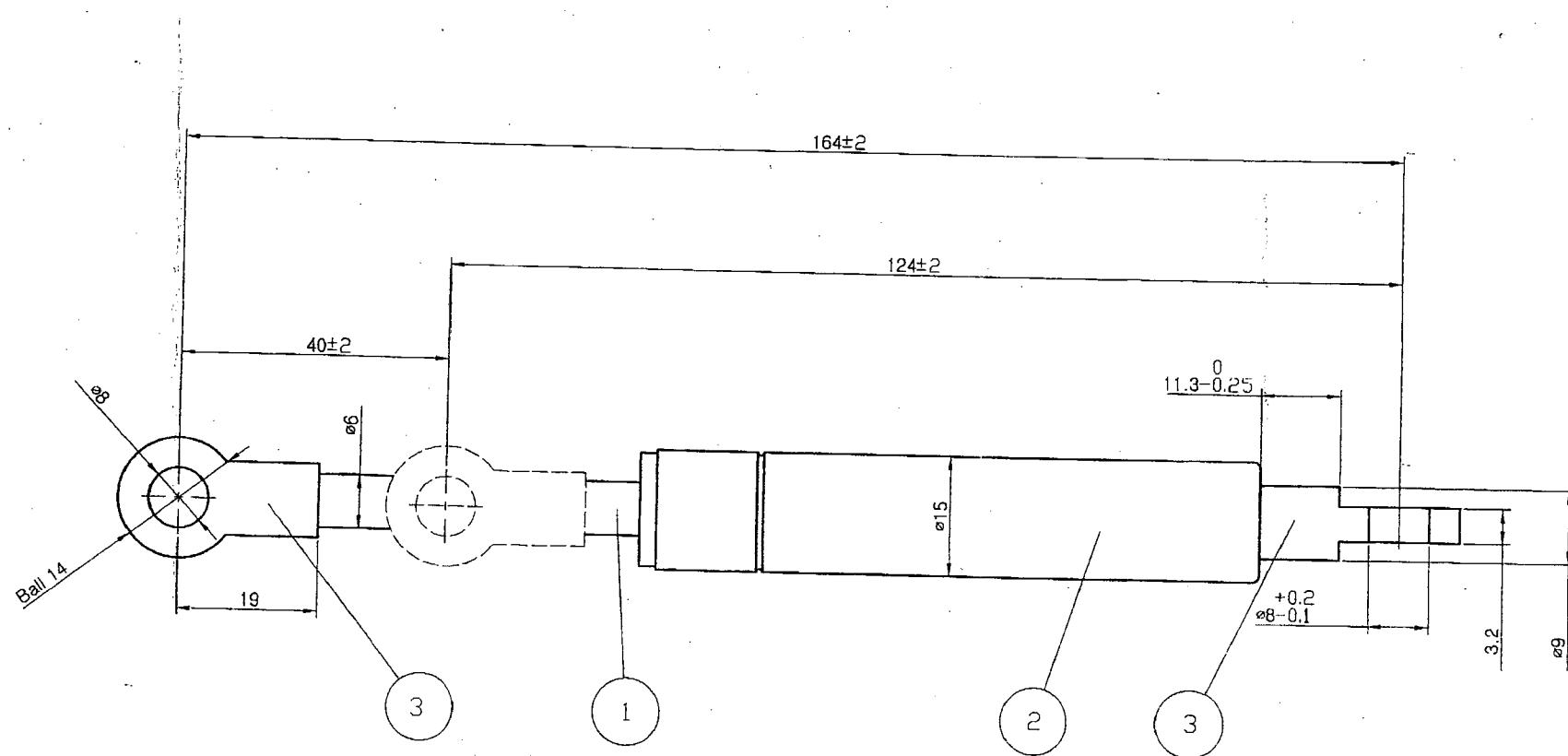
- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 lbs

NO. _____
 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

DESIGN	4	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	
MFG. APPR.	EG	REV. D	
APPROVED	MP	D2807	
DE APPR.	SH	SHEET 2 OF 2	
DATE	07.09.27	TITLE	SCALE
		GAS SPRING	3:1

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8 7 6 5 4 3 2 1



| Note

1. Force

All force are collected to 20+2C

$$1) F_t = (F_1 + F_2)/2 = 11.5 N + 20 N_{\text{net}}$$

$$2) F_c = (F_3 + F_4)/2 = 120 \text{ (REF)}$$

3) $F_r = F_3 - F_4 = \text{Max : } 20\text{N}_{\text{Net}}$

2. Appearance

No Harmful crack and scratch is not allowed

All leakage is not allowed

3. Application temperature range: -20~90.

Durability test

After 20,000 cycles at room temperature (-80-200 °C)

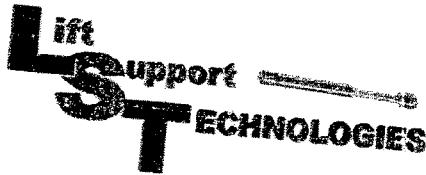
1) Unit must operated normal

2) Change rate of force is zero

2) Change rate of force is no more than 10% of initial value

value.

③	2	End Eye		SUS304
②	1	Cylind		SUS304
①	1	Rod		SUS304
NO	Qty	Part Name	Code No	Material
Desing	Bugil Park	④	Part Name	Gas Sp
Check			Part No	
Approval			Date	07.10.
Company			CANADA	
Model		6/15-164/50-115N		



P.O. Box 25032, Saskatoon, Saskatchewan, Canada S7K 8B7
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: info@lstechnologies.ca
Web: www.lstechnologies.ca

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.
100 Units: D2807 Stainless Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : December 11/2007

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 5053
Invoice # 3988

L S Technologies Inc Canada

Nolan Fehr
Manager

